

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006957**Date Inspected:** 15-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/15/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works, Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E1 - This completed section is stowed in Fabrication Shop #4. Following JSW excavation of jagged linear indications identified by QAI Mr Art Peterson on report MPT-000803 (dated 3/14/2009), QAI performed Magnetic Particle, dry continuous method, to verify the removal of said defects. No defects noted in excavation to PJP joint E1Y-5U edge.

W2E3 - (Saddle Cast section is joined with Built up section) Magnetic Particle (Dry Powder) inspection still being performed per instruction SF-MT-01 by Technician R.Kumagai #132 of welds. All inspection parameters appear met at this time. Technician was still in process to end of QA Inspector's review of shop operations.

W2W1 - (Saddle Cast section is joined with Built up section) QA Inspector observed K.Nakasato 91-2247, welding joint W1Y-17U-1 using FCAW per procedure SJ-3011-7 appeared to be approximately 75% complete of fill weld process; welder T.Watanabe 08-5153 was welding W1Y-17U-2 per SJ-3011-7, appeared 80% complete. All weld parameters were verified by QC CWI Chung F. Kuan. These operations continued through to end of QA Inspector's shift end.

W2W3 - All plates for built up section are now fit up and tacked in place, welder R.Kito is in process of attaching temporary attachments, anti-distortion strongbacks, using SMAW process with E7016 electrode in preparation for root passes to begin tomorrow.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

TOWER SADDLES

T1-2 - In preparation for attachment to base plate, all plate rib bevels have been ground smooth for MT by Technician R.Kumagai #132 prior to the beginning of fit up process.

T1-3 - Saddle is in process of being inverted to continue welding.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
